

**APPROVAL SHEET
FOR
AUTOMATED DATA LIST**


ADL 53711-5355799 Rev. C

NOMENCLATURE CARTRIDGE, 20MM, DUMMY, M51A4N, WITH MK 7
MOD 1 LINK

SIGNATURE

DATE

PREPARED BY:



N. BINDERT, G21 OSGA AEA

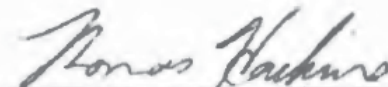
6 Feb 13

REVIEWED BY:



J. MICKOLAJCZYK, G2 CM LEAD

6 FEB 2013



T. HARKINS, G32 DESIGN AGENT

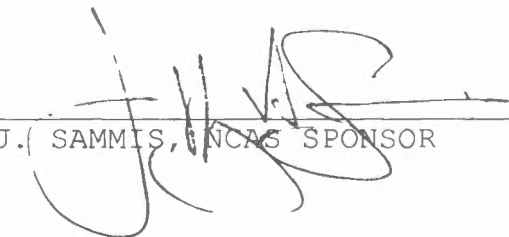
6 Feb 13

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6 Feb 13



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6 Feb 13



M. HAGN, G2 DIVISION HEAD

6 Feb 13

AUTOMATED DATA LIST (ADL)

ADL 53711-5355799C

SHEET 1 of 10

NSN 1305-01-448-9275

DODIC AA20

NOMENCLATURECARTRIDGE, 20MM, DUMMY, M51A4N, WITH MK 7 MOD
1 LINKASSEMBLY DRAWING

53711-5871720

Revision A

SPECIFICATION

N/A

APPROVAL SIGNATURE



MICHAEL HAGN, G2 DIVISION HEAD

DATE

6 Feb 13

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SCOPE OF WORK

FOR PROCUREMENT.

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NSN 1305-01-448-9275		DODIC AA20	
<u>DOCUMENT NUMBER</u>	<u>REV</u>	<u>NOMENCLATURE</u>	<u>SECURITY CLASS</u>
<u>DOCUMENTATION</u>			
<u>DRAWINGS</u>			
19200-12982855	B	CARTRIDGE, 20MM, PLASTIC DUMMY, M51A4N	
19200-12982856	A	HEADSTEM FOR CARTRIDGE, 20MM PLASTIC DUMMY, M51A4N	
10001-2923568	E	BELTED AMMUNITION, 20 MILLIMETER	
53711-5871720	A	LINKING, PACKING AND MARKING, DUMMY, 20MM CARTRIDGE	
19201-7258943	N	SHIPPING & STORAGE CONTAINER, CARTRIDGE, 20MM, M548	
19201-7258944	U	BODY ASSEMBLY	
19201-7258945	T	COVER ASSEMBLY	
19201-7258946	L	COVER	
19201-7258947	G	GASKET,COVER	
19201-7258948	K	RETAINER,GASKET	
19201-7258949	T	BODY	
19201-7258950	H	BOTTOM	
19201-7258951	K	REINFORCEMENT, BODY	
19201-7258952	K	HASP	
19201-7258953	J	LATCH	
19201-7258954	L	RETAINER LATCH LINK	
19201-7258955	J	LINK, LATCH	
19201-7258956	K	HANDLE	
19201-7258957	G	FERRULE	
19201-7258961	E	FILLER, LONG	
19201-7258964	H	SEPARATOR	
19203-8794342	AL	SEAL, METALLIC	
<u>DOCUMENTATION</u>			
<u>AUTOMATED DATA LISTS</u>			
10001-ADL564200	P	PALLET, MATERIAL HANDLING MK 3 MOD 0	

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<u>DOCUMENT NUMBER</u>		<u>REV</u>	<u>NOMENCLATURE</u>			<u>SECURITY CLASS</u>
53711-ADL5871716		T	LINK, 20MM CARTRIDGE, MARK 7 MOD 1			
<u>DOCUMENTATION</u>						
<u>TECHNICAL DATA PACKAGE LISTS</u>						
19200-TDPL12982855		03/25/1999		CARTRIDGE, 20MM, PLASTIC DUMMY, M51A4N		
<u>DOCUMENT NUMBER</u>		<u>REV</u>	<u>CHG CAT</u>	<u>LEVEL</u>	<u>NOMENCLATURE</u>	<u>SECURITY CLASS</u>
<u>SPECIFICATIONS</u>						
<u>SYSTEM</u>						
19200-DTL12982855		-		CARTRIDGE, 20MM, PLASTIC DUMMY M51A4N		
10001-WS18782		C		PAINTING, MARKING, AND LETTERING OF NAVAL GUN AMMUNITION		
<u>SPECIFICATIONS</u>						
<u>FEDERAL</u>						
A-A-59135		-		PACKAGING MATERIAL, SHEET		
FF-S-2738		A AMD		1 SEALS, ANTIPILFERAGE		
PPP-F-320		D IA		5 FIBERBOARD: CORRUGATED AND SOLID, SHEET STOCK (CONTAINER GRADE), AND CUT SHAPES		
TT-C-490		E		CHEMICAL CONVERSION COATINGS AND PRETREATMENTS FOR FERROUS SURFACES (BASE FOR ORGANIC COATINGS)		
<u>SPECIFICATIONS</u>						
<u>MILITARY</u>						
MIL-A-2550		B AMD		1 AMMUNITION, GENERAL SPECIFICATION FOR		
MIL-S-23389		B AMD		3 SHIPPING AND STORAGE CONTAINER CARTRIDGE, 20MM, M548		
<u>STANDARDS</u>						
<u>FEDERAL</u>						
FED-STD-595		C CN		1 COLORS USED IN GOVERNMENT PROCUREMENT		
<u>STANDARDS</u>						
<u>MILITARY</u>						
MIL-STD-1168		B		AMMUNITION LOT NUMBERING AND AMMUNITION DATA CARD		
MIL-STD-129		P CHG		4 MILITARY MARKING FOR SHIPMENT AND STORAGE		
MIL-STD-1323-187		- NOT		1 CARTRIDGE, 20MM, M50 SERIES BELTED WITH MK7 OR M-14 LINKS IN CONTAINER, M548		

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DOCUMENT NUMBER	REV	CHG CAT	LEVEL	NOMENCLATURE	SECURITY CLASS	
<u>STANDARDS</u>						
<u>INDUSTRY</u>						
ASME B94.6	03			KNURLING		
ASME Y14.100	04			ENGINEERING DRAWING PRACTICES		
ASME Y14.5M	94			DIMENSIONING AND TOLERANCING		
ASTM A108	07			STANDARD SPECIFICATION FOR STEEL BAR, CARBON AND ALLOY, COLD-FINISHED		
ASTM A109/A109M	08			STANDARD SPECIFICATION FOR STEEL, STRIP, CARBON (0.25 MAXIMUM PERCENT), COLD-ROLLED		
ASTM A29/A29M	12			STANDARD SPECIFICATION FOR STEEL BARS, CARBON AND ALLOY, HOT-WROUGHT, GENERAL REQUIREMENTS FOR		
ASTM A380	06			CLEANING AND DESCALING STAINLESS STEEL PARTS, EQUIPMENT, AND SYSTEMS		
ASTM A568/A568M	11			STANDARD SPECIFICATION FOR STEEL, SHEET, CARBON, STRUCTURAL, AND HIGH-STRENGTH, LOW-ALLOY, HOT-ROLLED AND COLD-ROLLED, GENERAL REQUIREMENTS FOR		
ASTM A582/A582M	12			STANDARD SPECIFICATION FOR FREE-MACHINING STAINLESS STEEL BARS		
ASTM A641/A641M	09			STANDARD SPECIFICATION FOR ZINC-COATED (GALVANIZED) CARBON STEEL WIRE		
ASTM A853	10			STANDARD SPECIFICATION FOR STEEL WIRE, CARBON, FOR GENERAL USE		
ASTM D2000	12			STANDARD CLASSIFICATION SYSTEM FOR RUBBER PRODUCTS IN AUTOMOTIVE APPLICATIONS		
ASTM D4066 REV A	08			STANDARD CLASSIFICATION SYSTEM FOR NYLON INJECTION AND EXTRUSION MATERIALS (PA)		
ASTM D4727/D4727M	12			STANDARD SPECIFICATION FOR CORRUGATED AND SOLID FIBERBOARD SHEET STOCK (CONTAINER GRADE) AND CUT SHAPES		
ASTM E8/E8M	11			STANDARD TEST METHODS OF TENSION TESTING OF METALLIC MATERIALS		
AWS A2.4	12			STANDARD SYMBOLS FOR WELDING, BRAZING AND NONDESTRUCTIVE EXAMINATION		
AWS A3.0	10			STANDARD WELDING TERMS AND DEFINITIONS INCLUDING TERMS FOR ADHESIVE BONDING, BRAZING, SOLDERING, THERMAL CUTTING, AND THERMAL SPRAYING		

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DOCUMENT
NUMBER

REV

CHG
CAT

LEVEL

NOMENCLATURE

SECURITY
CLASSPUBLICATIONS

DOCUMENT NUMBER	REV	CHG CAT	LEVEL	NOMENCLATURE	SECURITY CLASS
DI-MISC-80043	B			AMMUNITION DATA CARD	
MIL-HDBK-1461	A			AMMUNITION MANUFACTURERS AND THEIR SYMBOLS	
PL 102-484 SECT 326	-			NATIONAL DEFENSE AUTHORIZATION ACT FOR FISCAL YEAR 1993 OZONE DEPLETING CHEMICALS	

EXCEPTIONS TO DOCUMENTATION1. 19200-12982855

1.1 ZONE D5, CHANGE FROM "3.462" TO "3.467 + .000 -.012, NOTE 9".

1.2 ZONE C5, CHANGE FROM "(3.3128)" TO "(3.3151)".

1.3 ZONE C4, CHANGE FROM "ø .940" TO "ø .942".

1.4 ZONE B5, CHANGE FROM "ø 1.100" TO "ø1.104 + .000 - .008".

1.5 ZONE B5, CHANGE FROM "(ø 1.0457) MMC" TO "(ø 1.0496) MMC".

1.6 ZONE B4, CHANGE FROM "ø .822" TO "ø.822 + .000 - .010".

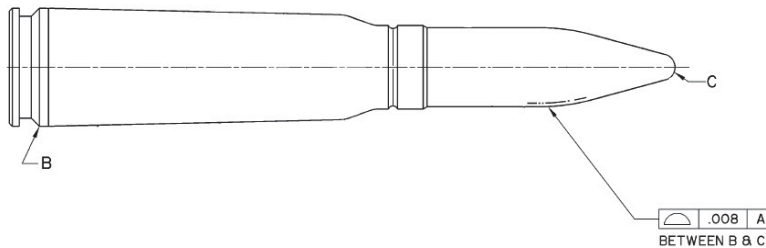
1.7 ZONE C4, CHANGE FROM "R .05" TO "R .050".

1.8 ADD NEW NOTE 9 AS FOLLOWS:

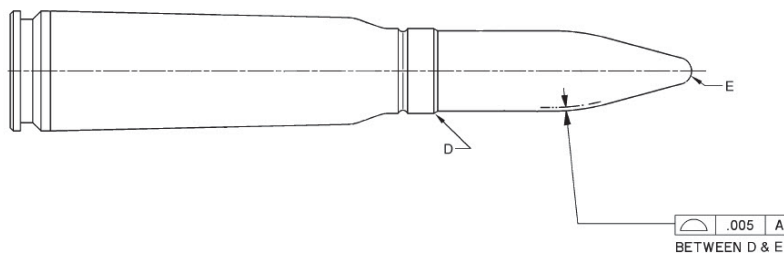
"9. THIS DIMENSION TO BE MEASURED USING A 7/64 INCH THICK RING, POSITIONED NORMAL TO THE CARTRIDGE AXIS, WITH A 39° BASIC INCLUDED INSIDE ANGLE WITH THE .942 DATUM DIAMETER LOCATED MIDWAY ON THE MEASURING SURFACE."

1.9 CHANGE PROFILE TOLERANCE AND APPLICATION,

FROM:



TO:



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NSN 1305-01-448-9275

DODIC AA20

1.10 NOTE 1, CHANGE "ANSI Y14.5M-1982" TO "ASME Y14.5M-1994".

1.11 ZONE F8, CHANGE NOTE 2 AS FOLLOWS:

FROM: "2. BODY MATERIAL: NYLON 66, 33% FIBERGLASS REINFORCED, TOUGHENED, ASTM D4066: PA0160G33"

TO: "2. BODY MATERIAL: NYLON 66, 33% FIBERGLASS REINFORCED, TOUGHENED, ASTM D4066: PA0160G33. SUGGESTED SOURCE OF SUPPLY: RTP CO., WINONA, MN. P/N 299 HX-118112 TAN SS-32634".

1.12 ZONE F8, CHANGE NOTE 3 AS FOLLOWS:

FROM: "3. BODY COLOR, COLOR NO. 33722 OF FED-STD-595. TITANIUM DIOXIDE IS NOT TO BE USED IN THE FORMULATION OF THE COLORANT. COLORANT LOADING BY WEIGHT SHALL NOT EXCEED 0.22 PERCENT".

TO: "3. BODY COLOR; APPROXIMATE COLOR NO. 33722 OF FED-STD-595 TITANIUM DIOXIDE IS NOT TO BE USED IN THE FORMULATION OF THE COLORANT. COLORANT LOADING BY WEIGHT SHALL NOT EXCEED 0.22 PERCENT".

2. 19200-12982856

2.1 CHANGE NOTE 2 TO READ:

"2. HEAD MATERIAL: STAINLESS STEEL, ASTM A582, TYPE 303 (UNS:S30300), CONDITION A: ANNEALED. AFTER MACHINING AND BEFORE ASSEMBLY WITH STEM, PASSIVATE IN ACCORDANCE WITH ASTM A380."

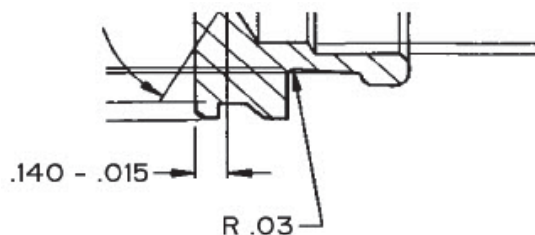
2.2 ZONE C6, CHANGE FROM " \varnothing 1.148 - .008" TO " \varnothing 1.152 + .000 - .008, SEE NOTE 7".

2.3 ZONE C7, CHANGE FROM ".099 - .007" TO ".077 \pm .004".

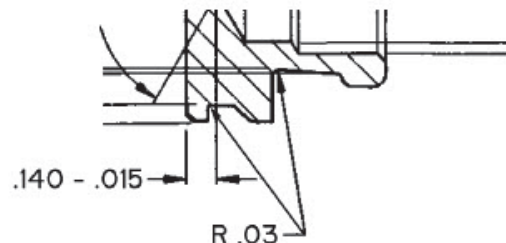
2.4 ZONE C7, CHANGE FROM ".120 + .010" TO ".140 + .010 - .000".

2.5 ZONE B7, CHANGE .03 IN. RADIUS CALLOUT

FROM:



TO:



2.6 NOTE 1, CHANGE "ANSI Y14.5M-1982" TO "ASME Y14.5M-1994".

2.7 ZONE C8, CHANGE " \varnothing 1.165 - .010" TO " \varnothing 1.165 - .010, SEE NOTE 7".

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- 2.8 ZONE D8, ADD NEW NOTE 7 TO READ: "CARTRIDGE SUPPLIER IS TO BE CONTACTED AND AN AGREED UPON SIZE OF THIS DIAMETER SHALL BE SELECTED UPON WHICH A $\pm .001$ TOLERANCE SHALL BE APPLIED.
- 2.9 ZONE C6, ADD A $.025 \pm .005$ X 45° CHAMFER TO THE EDGE OF THE $1.152 + .000 - .008$ DIAMETER (REFERENCE ADL CHANGE 2.2).
- 2.10 ZONE D3, CHANGE " $5.920 - .020$ " TO " $5.915 - .020$ ".
- 2.11 ZONE C7, CHANGE " $.400 + .010$ " TO " $.405 + .010$ ".
- 2.12 ZONE C7, ADD A LENGTH FROM THE BOTTOM OF THE HEAD TO THE INTERSECTION OF THE $.720 + .010$ DIAMETER, THE LENGTH IS $.695 - .010$.
- 2.13 ZONE C7, ADD A 3° REFERENCE ANGLE BETWEEN THE $.680 + .010$ DIAMETER AND THE $.720 + .010$ DIAMETER, THE ANGLE SHOULD BE NOTED ON THE DRAWING AS (3°).
- 2.14 ZONE B4, CHANGE " 1.25 " TO " $1.25 \pm .030$ ".
- 2.15 ZONE B5, CHANGE " 3.50 " TO " $3.50 \pm .030$ ".

3. DTL12982855

- 3.1 TABLE II. PAGE 7, ADD NEW NOTE 2, WHICH APPLIES TO BOTH HEADSTEM AND DUMMY CARTRIDGE EXAMINATION FOR DEFECTS, TO READ:

"2. TEN SAMPLE CARTRIDGES AND HEADSTEMS SHALL BE INSPECTED FOR ALL DIMENSIONS AND FEATURES CONTAINED ON THEIR RESPECTIVE DRAWINGS."

- 3.2 TABLE III. PAGE 9, CHANGE MAJOR CHARACTERISTICS M102 AND M013 TO READ AS FOLLOWS"

"102	0.140 + 0.010, WIDTH OF EXTRACTOR GROVE	IV	3.4	GAGE
103	0.077 \pm 0.004, THICKNESS OF EXTRACTOR RIM	IV	3.4	GAGE"

- 3.3 TABLE III. PAGE 10, ADD MAJOR CHARACTERISTICS M109 AND M110 AS FOLLOWS:

"109	3.467 + .000 - .012, LENGTH TO .942 BASIC DIAMETER	IV	3.4	GAGE
110	1.104 + .000 - .008, DIAMETER AT 1.761 BASIC	IV	3.4	GAGE"

- 3.4 PAGE 6, ADD THE FOLLOWING NEW PARAGRAPH:

"4.2.4 CYCLE TEST. IN ADDITION TO THE SPECIFIED FIRST ARTICLE INSPECTION REQUIREMENTS, AN ADDITIONAL PREPRODUCTION SAMPLE OF 500 M51A4N 20MM DUMMY CARTRIDGES SHALL BE PROVIDED IN THE LINKED CONFIGURATION. THE CARTRIDGES SHALL BE CYCLE TESTED IN A MK 15, BLOCK 1, CLOSE-IN WEAPONS SYSTEM (CIWS). THE CYCLE TEST SHALL CONSIST OF TWO UPLOAD AND DOWNLOAD CYCLES. THE FIRST CYCLE WILL INCLUDE UPLOAD OF THE 500 CARTRIDGES INTO THE AMMUNITION HANDLING SYSTEM. ALL 500 CARTRIDGES WILL BE CYCLED THROUGH THE CLEARING PATH OF THE GUN AT A RATE OF 250 TO 300 ROUNDS PER MINUTE. THE CARTRIDGES WILL THEN BE DOWNLOADED FROM THE DRUM AND PLACED BACK IN THE MK 7 LINKS. THE SECOND CYCLE WILL INCLUDE UPLOAD OF ALL 500 CARTRIDGES, CYCLING OF THE CARTRIDGES THROUGH THE FIRING PATH WHILE CHECKING THE FIRING CIRCUIT CONTINUITY THROUGH THE CARTRIDGE BASE BY CONDUCTING THE CIWS PERIODIC SYSTEM OPERABILITY TEST (PSOT) 14 TEST, AND THEN DOWNLOAD OF THE CARTRIDGES INTO

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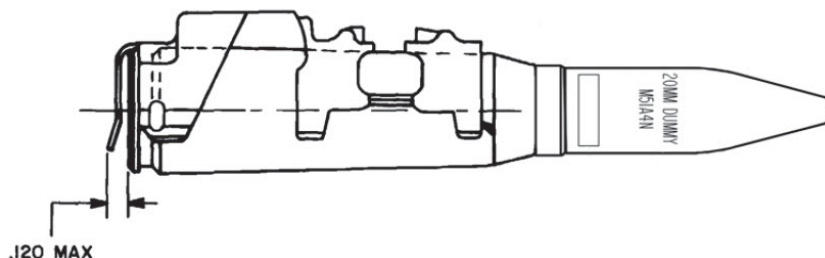
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THE LINKS. THE PSOT 14 TEST WILL BE CONDUCTED AT A RATE OF 4500 ROUNDS PER MINUTE IN 90 ROUND BURSTS. THE CARTRIDGES SHALL UPLOAD, CYCLE, AND DOWNLOAD SMOOTHLY WITH NO GUN SYSTEM STOPPAGES OR DAMAGE. AFTER EACH DOWNLOAD, THE LINKED BELTS OF DUMMY CARTRIDGES SHALL BE INSPECTED FOR PROPER PLACEMENT OF THE CARTRIDGES IN THE LINKS. THE DETENT IN THE BASE OF THE LINK SHALL BE PROPERLY SEATED IN THE EXTRACTION GROOVE OF THE DUMMY CARTRIDGES, AS SHOWN BELOW. THE CYCLE TEST WILL BE PERFORMED AT NAVAL SURFACE WARFARE CENTER, DAHLGREN DIVISION. THE TESTING WILL BE PERFORMED AT GOVERNMENT EXPENSE AND ACCORDING TO THE GOVERNMENT'S SCHEDULE UPON RECEIPT OF THE DUMMY CARTRIDGES. THE 500 LINKED DUMMY CARTRIDGES SHALL BE SHIPPED FOB DESTINATION TO THE FOLLOWING ADDRESS:

AMMUNITION OFFICER
NSWC/DAHLGREN DIVISION
17320 DAHLGREN ROAD
DAHLGREN, VA 22448
ATTN: CODE G635
MARK FOR JAY FITZSIMMONS, CODE G33



3.5 PAGE 10, CHANGE MAJOR CHARACTERISTIC M104 AS FOLLOWS:

FROM: "3975 \pm 100 GRAINS, WEIGHT OF CARTRIDGE"

TO: "3887 \pm 85 GRAINS, WEIGHT OF CARTRIDGE"

3.6 PAGE 15, CHANGE METHODS OF INSPECTION 4.4.3 IMPACT TEST AS FOLLOWS:

FROM: "DEFORMATION AND CRACKING (LESS THAN 1/8 OF AN INCH IN LENGTH) IN THE TIP, NOSE AREA IS PERMITTED"

TO: "DEFORMATION AND CRACKING (LESS THAN 1/2 OF AN INCH IN LENGTH) IN THE TIP, NOSE AREA IS PERMITTED"

4. 53711-5871720

4.1 IN NOTE 2.1, CHANGE "FIND NUMBER 2" TO "FIND NUMBER 2 OR 8".

4.2 ADD NOTE 2.3, NO MORE THAN TWO LINK LOTS SHALL BE USED IN LINKING A CARTRIDGE LOT.

4.3 IN NOTE 3.1, CHANGE "UP" TO "DOWN" AND "FLAKED" TO "PLACED".

4.4 IN NOTE 3.3, DELETE "SINGLE".

4.5 IN NOTE 3.5, CHANGE NOTE TO READ "THE BOX SHALL CONTAIN THE FOLLOWING PRE-PACKING, PPP-F-320 OR ASTM D4727, SUFFICIENT TO PROVIDE A SNUG FIT: BOTTOM SPACERS, SIDE SPACERS, END SPACERS, AND TOP SPACERS."

4.6 ADD NOTE AS FOLLOWS: "3.6 SEPARATOR, FIND NUMBER 7, TO BE USED AS SHOWN."

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4.7 NOTE 5, ADD TO END OF NOTE "AND THE FOLLOWING:

NALC/DODIC: AA20
NSN: 1305-01-448-9275
UN SERIAL NUMBER: N/A
PROPER SHIPPING NAME: N/A
POP: N/A".

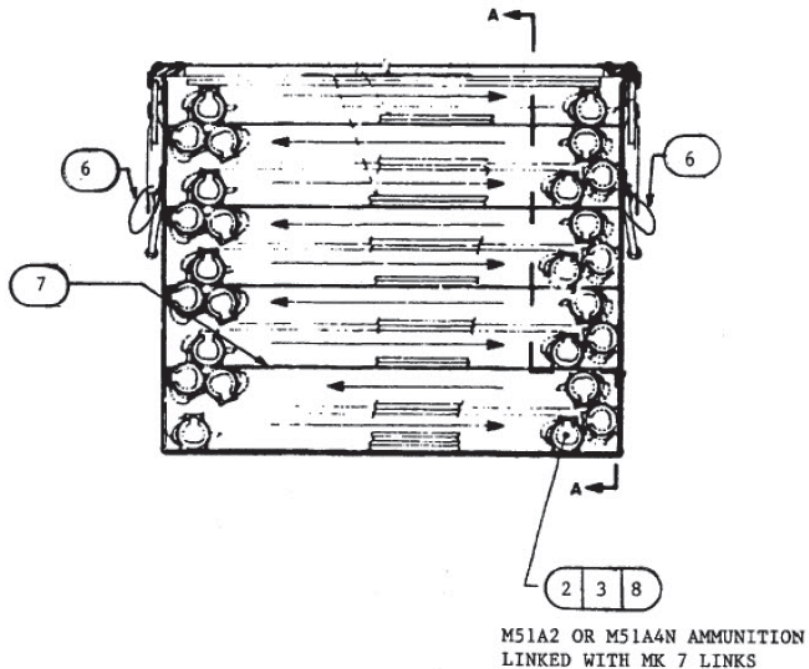
4.8 IN NOTE 6, CHANGE "MIL-STD-1322-31" TO "MIL-STD-1323-187".

4.9 ADD NOTE AS FOLLOWS: "7. APPLICABLE REQUIREMENTS OF MIL-STD-129 APPLY."

4.10 TO PARTS LIST, ADD THE FOLLOWING LINES:

"8	100	19200	12982855	CARTRIDGE, 20MM, PLASTIC DUMMY, M51A4N	NOTE 2.1
7	4	19201	7258964	SEPARATOR	NOTE 3.6
6	2	19200	8794342	SEAL METALLIC ASSEMBLY	NOTE 4 "

4.11 ON SHEET TWO, ADD FIND NUMBERS 6, 7, AND 8, AS SHOWN:



4.12 IN NOTE 3.4, CHANGE "MIL-STD-1167" TO "MIL-STD-1168".

4.13 CHANGE NOTE 2.1 TO READ: "2.1 CARTRIDGES, FIND NO. 2 OR 8, SHALL BE LINKED IN A BELT OF 100 CARTRIDGES IN ACCORDANCE WITH DRAWING 10001-2923568".

5. 19201-7258961

5.1 MATERIAL BLOCK, CHANGE "SPEC PPP-F-320" TO "SPEC PPP-F-320 OR ASTM D4727".

5.2 SHEET 2, NOTE 1 CHANGE "PPP-C-1752" TO "A-A-59135".

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6. 19201-7258964

6.1 SHEET 2, NOTE 1 CHANGE "PPP-C-1752" TO "A-A-59135".

7. 19203-8794342

7.1 NOTE 2A, CHANGE "PRONG-LOK PRO-4" TO "PRONG-LOCK PRO-4 (ALUMINUM)".

8. 10001-2923568

8.1 PARTS LIST, ADD NEW FIND NO. "5", QTY "1", NOMENCLATURE "CARTRIDGE, 20MM, DUMMY, M51A4N", CODE IDENT "19200", PART OR IDENTIFYING NO. "12982855".

8.2 ZONE B4, NEXT TO " (3) OR (4) " ADD "OR (5) ".

8.3 PARTS LIST, FIND NO. 1, CHANGE PART OF IDENTIFYING NO. FROM "5871716" TO "ADL5871716".

8.4 NOTES, CHANGE NOTE 2 TO READ "2. PACKAGE IN ACCORDANCE WITH DRAWING 53711-5871720."

ADDITIONAL REQUIREMENTS

1. CHANGE MIL-STD-100 AND DOD-STD-100 TO ASME Y14.100 EVERYWHERE IT APPEARS.

2. THE CONTRACTOR SHALL PREPARE AMMUNITION DATA CARDS IN ACCORDANCE WITH MIL-STD-1168, DI-MISC-80043 AND CONTRACT DATA REQUIREMENTS LIST AND DELIVER THEM WITH EACH DELIVERABLE LOT. DATA CARDS SHALL AT A MINIMUM LIST THE FOLLOWING COMPONENTS:

A. LINK

THE END ITEM AND COMPONENT ADL OR TDPL NUMBERS AND REVISIONS SHALL BE LISTED IN LIEU OF DRAWING NUMBERS.

3. THE CONTRACTOR SHALL USE NO CLASS I ODS IN THE MANUFACTURER OF PROPELLING CHARGES. ODS ARE THOSE SUBSTANCES DEFINE IN PUBLIC LAW 102-484 SECTION 326.